

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23453
<b>Description:</b> Wearplate	<b>Part Number:</b>	D3321-3
<b>Dwg:</b> D3321 Rev. A page 3	<b>Qty:</b>	<del>10</del> 3 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	05.05.30	10
2	PG	Issue P/O: <u>2008031</u> <b>Email or Ship DXF file to vendor</b> Laser Cut flat pattern per Dwg D3321 Possible Supplier: Industrial Laser <b>Material release note is required</b>	U	05.05.30	10
3	RG	Receive and inspect for transit damage <b>Ensure material release note is attached</b>	CL	05.05.30	10
4	QC6	Inspect dimensions as per inspection template D3321-3T1	U	05.05.30	10
5	GA	Deburr if necessary	U	05.05.30	10
6	GB	Form using DT8179 Die & DT8774 as per Dwg D3321 Dwg Rev: <u>A</u>	U	05.05.30	3
7	QC6	Inspect dimensions as per Dwg D3321	U	05.05.30	3
8	WS	Weld hard surface using D3321-3T3 as per QSI 004 and Dwg D3321 Dwg Rev: <u>A</u> Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod M16901	epl	05.05.31	3
9	QC9	Inspect weld	U	05.05.31	3
10	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	U	05.05.31	3
11	QC3	Inspect Powder Coat	U	05.06.01	3
12	ST	Identify on inside surface using a permanent fine point marker with the following: <b>TCCA-PDA, Dart Aerospace Ltd.</b> <b>P/N: D3321-3, B/N: BXXXXX</b> <b>For Product Eligibility see PDA04-17 and Stock</b>	U	05.06.01	3
13	AC	Cost / part: <u>18.18</u>	SAC	05.06.28	3
14	DC	Close W/O <u>18.18</u> Inspect Level 21	U	05.07.13	3

Rev	Date	Change	Revised By	Approved
A	05.05.12	New issue	KJ/JLM	

PRELIMINARY ISSUE

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
05.05.30	4	Aft most hole ( $\phi 0.766$ ) elongated 0.080" to allow for better fit. Tested on skid tube and confirmed fit. PERMANENT CHANGE ON D3321 PH.	PH	05.05.23	3		
050530	4	Scrap remaining pieces total 7		050530	7		

NCR		WORK ORDER NON-CONFORMANCE					
DATE	STEP	Description of NC section A	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector

PAR#: N/A Fault Category: N/A DQA: Date: 05/07/13

NOTE: Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

002

INDUSTRIAL LASER CUTTING -> DART

05/27/2005 08:54 FAX 804 946 4153

ALCOA STEEL P. 6

ALCOA STEEL INCORP. 165 West St., Sault Ste. Marie, Ontario, Canada, P6A 7B4

CUSTOMER PURCHASE ORDER NUMBER P31529ME003	ENTRY DATE 2003/05/02	SHIP DATE 2003/09/08	TALLY NUMBER 920195	INVOICE NUMBER 09-	CARRIER CP	ALCOA ORDER -344750	44503
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SHIP TO CUSTOMER NAME & ADDRESS  
WILKINSON A DIVISION OF PREMETALCO INC  
888 SOUTH EAST MARINE DRIVE  
VANCOUVER BRITISH COLUMBIA  
V5X 2V3

SHIP TO CUSTOMER NAME & ADDRESS  
WILKINSON A DIVISION OF PREMETALCO INC  
888 SOUTH EAST MARINE DRIVE  
NEW WESTMINSTER BRITISH COLUMBIA

MILL TEST REPORTS

ALCOA STEEL INC. HEREBY CERTIFIES THAT THE MATERIAL HEREIN DESCRIBED WAS MADE AND TESTED IN ACCORDANCE WITH THE LIMITS OF THE SPECIFICATION SHOWN HEREIN AS CONTAINED IN THE COMPANY RECORDS AND WITHIN THE SCOPE OF ACCREDITATION OF ISO/IEC 9001:2000 AS CONTAINED IN THE COMPANY RECORDS.

K. Haldenby  
MANAGING METALLURGIST

THIS MILL TEST REPORT MAY NOT BE REPRODUCED EXCEPT IN FULL WITHOUT WRITTEN APPROVAL OF ALCOA STEEL INC. IF YOU RECEIVE THIS DOCUMENT AND ARE NOT THE INTENDED RECIPIENT, PLEASE CALL 1-800-393-2224 COLLECT FOR INSTRUCTIONS ON METHOD OF DISPOSAL OF DOCUMENT.

CUSTOMER SPECIFICATION  
HOT ROLLED STEEL SHEET - CARBON - ASTM A569 TYPE B (90) - CS - MATTE - P & OIL  
(N/FINISH) - CUT EDGE ACCEPTABLE - ( AIM FOR LIGHT SIDE OF GAUGE & NO COIL  
BREAKS ) - ( FLATNESS CRITICAL )

SUPPLEMENTARY INSTRUCTIONS  
FBI SM ATTN K ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON  
COVERED GONDOLA"

NOTE THE  
CHEMICAL ANALYSIS REPORT REQUIRED  
ELECTRICAL PANELS

\*\*\*\*\* PRODUCT SHIPPED \*\*\*\*\*  
CUSTOMER ITEM 1 OUR ITEM 001 DIMENSIONS .059 X 48 X COIL

COIL NUMBER	HEAT	NO. PIECES	WEIGHT	COIL NUMBER	HEAT	NO. PIECES	WEIGHT
9341882	5653B-02	1	23170	9341888	5653B-52	1	24290

\*\*\*\*\* CHEMICAL PROPERTIES \*\*\*\*\*  
HEAT 5653B C .04 MN .26 P .006 S .005 SI .02 CR .02 NI .01 CU .01 MO .00 AL .029 CB .005 V .008 B .008 TI .008 SN .008 N .008

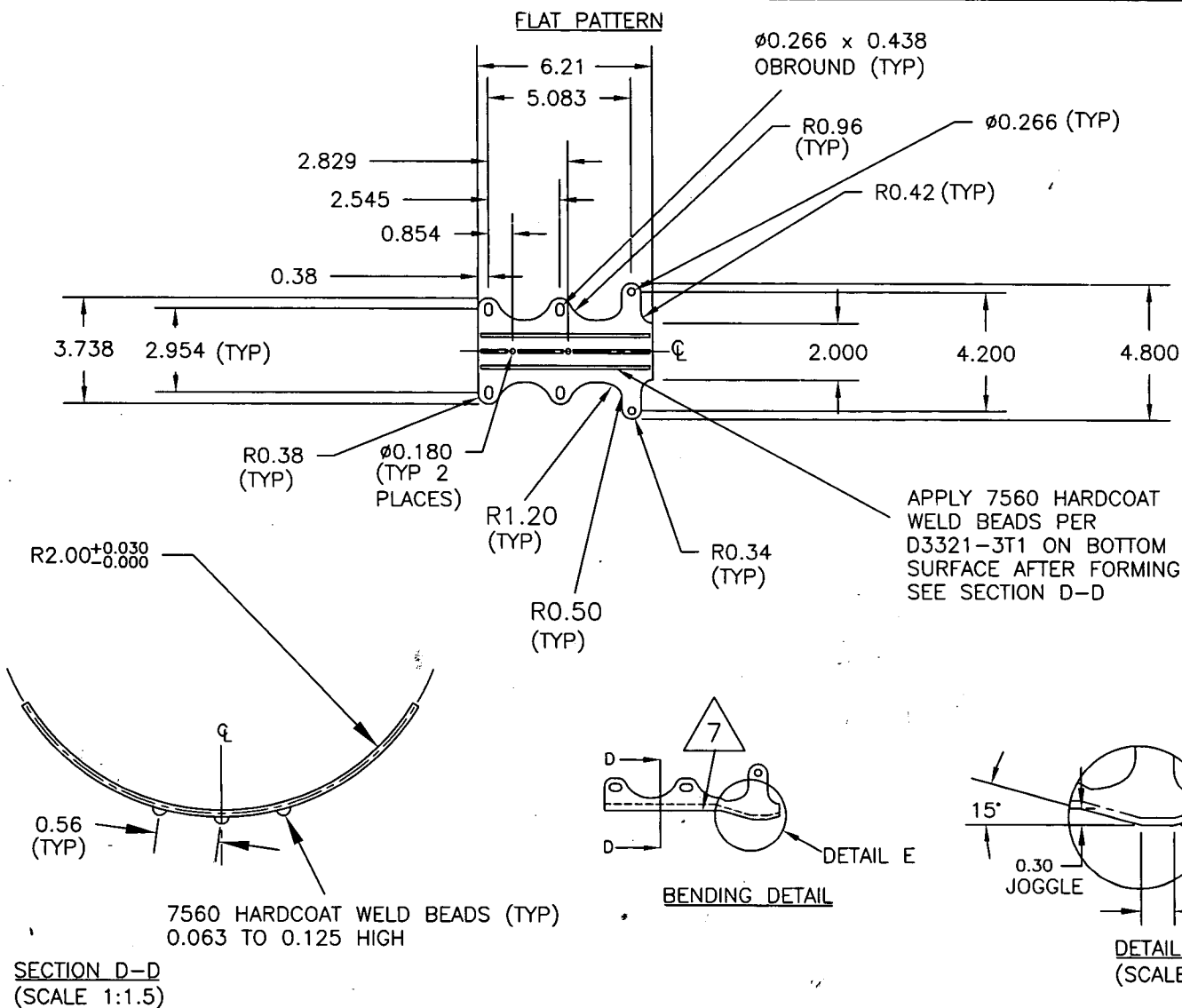
16ga crms

16 ga crms  
0.059"

\*\*WARNING\*\*

THE TEST RESULTS AND VALUES REPORTED HEREIN INDICATE ONLY THAT (1) THE PARTICULAR STEEL FOR WHICH THIS CERTIFICATE IS ISSUED MEETS THE MINIMUM SPECIFIED YIELD STRENGTH AND (2) THE CHEMICAL ANALYSIS AND PHYSICAL PROPERTIES OF SUCH STEEL ARE IN CONFORMANCE WITH THE REQUIREMENTS OF THE SPECIFICATION INDICATED. THE RESULTS OR VALUES REPORTED HEREIN CAN NOT BE USED TO QUALIFY THE STEEL FOR ANY SPECIFICATION OTHER THAN THE ONE INDICATED AND CAN NOT BE RELIED UPON FOR ANY PURPOSE (INCLUDING DESIGN OR CALCULATIONS) AS REPRESENTED THE ACTUAL STRENGTH OF SUCH STEEL.

**PRELIMINARY  
ISSUE**



**D3321-3 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) ALL DIMENSION ARE IN INCHES
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3321-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA04-XX"

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
04.10.01	D3321	SHEET 2 OF 2
	TITLE	SCALE
	WEARPLATE	1:6